

Work Order ID 50848

July 31, 2009 8:35:00 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 08/20/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/04/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 09-08-04

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580	Rev D

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A *[Signature]*

110 0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

[Signature]

[Signature]

MB 09-08-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

① 0 09-08-31

130

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

278 09/08/31

④ 0

W/O:		WORK ORDER CHANGES					
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Run Start



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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004.

A/R U U U Aluminum Rod

mill 682 BC 09/08/31

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R U U U Aluminum Rod

mill 682 BC 09/08/31

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

- AWM 9-9-10

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Run Start



Approvals: Process Plan: Date:

Tooling: Date:

QC: Date:

SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

27 08/09/14

(40)

/

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

27 08/09/14

(40)

/

Quality Control

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

27 08/09/14

(40)

/

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

N1112260

0.00

Powder Coating

START TIME:

9:00AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:30AM

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DR 09-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 M112391 ☐Sikaflex expire date: 10/202-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as
per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 M112391 ☐Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M112106

BR 09-09-16 ①.

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 08/20/2009 Start Qty: 1.00

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Required Date: 09/04/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00

2) 8-9/09/16



QC

Quality Control

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

230

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

C 209/09/30

AP

51269 9/9/28 QSP

09/09/30 HJ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

July 31, 2009 8:35:00 AM

Page 1

Work Order ID: 50848



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 08/20/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	7.0000	1.0000			
								7		1	B 50977	B 51477
205 Skidtube bent detail								*			B-50168	MB 09-08-28

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 7

48616 1

50760 6

D2576-3RevG

Manufactured No



140

Each

165.0000

1.0000



Step (maching detail)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 165

43504 62

46661 103

1 BE 09/08/1

Picklist Print

July 31, 2009 8:35:00 AM

Page 2

Work Order ID: 50848

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube



Start Date: 08/20/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	412.0000	20.0000			
												

Crossbolt Spacer

Warehouse
Location
Main Warehouse
ST

Loc Qty

Loc Code

251315 (x20) 25 09/08/31

412
4
4
12
338
54

D2855RevA

Manufactured No

200 Each 66.0000 1.0000



Cap

Warehouse
Location
Main Warehouse
FP6
50513
Main Warehouse
ST

Loc Qty

Loc Code

52
52
14
2
7
1
3
2
-1

1 09/09/16

July 31, 2009 8:35:00 AM

Shop Packet Print

Page

Picklist Print

July 31, 2009 8:35:00 AM

Work Order ID: 50848



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube


Start Date: 08/20/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A  Bolt		Purchased	No			200	Each	2,560.000	2.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 2560

100188 246

105057 ✓ 2246

15205 68

2 Bk 09-09-16.

AN960JD10L

Purchased

No

200

Each

6,911.000 2.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 6911

101291 16

104885 153

105793 236

109632 ✓ 1506

110985 5000

2 Bk 09-09-16.

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ALS7-1032-130		Purchased	No			200	Each	3,706.000	50.0000			
												
Insert												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	3706	
105855	16	
108606	52	
111529	1638	
111779 ✓	2000	

AN3C4A

Purchased

No

200

Each

2,071.000

50.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 112612	2071	
112082	121	
112314	1950	

50 BR 09-09-16.

50 BR 09-09-16.

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			200	Each	4,591.000	50.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	4491	
112116 ✓	4491	

50 Bl 09-09-16

D3566-13RevC

Manufactured No



Gasket

200 Each 47.0000 1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	47	
45717	1	
46889	5	
47435	7	
48166	18	
50265 ✓	16	

1 Bl 09-09-16

W/O:		WORK ORDER CHANGES					
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Comments:

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D3566-5RevC		Manufactured	No			200	Each	22.0000	1.0000			
Gasket												

Warehouse Loc Qty Loc Code
Location

Main Warehouse 51669

ST	22	
36113	1	
46186	1	
47318	1	
48167	19	

1 BR 09-09-16

D3566-1RevC

Manufactured No

200

Each

34.0000

2.0000



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse 51612

ST	34	
46349	1	
47434	2	
48165	8	
48557	11	
50278	12	

2 BR 09-09-16

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D3564-11RevD 		Manufactured	No			200	Each	30.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

51256

1 BR 09-09-16

ST

30

45823

1

47432

7

48553

12

50112

10

D3564-13RevD

Manufactured

No

200

Each

55.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17

35

48554

13

50270 ✓

22

Main Warehouse

ST

20

45409

3

46495

10

47867

7

1 BR 09-09-16

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube



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Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD  Wearshoe		Manufactured	No			200	Each	17.0000	1.0000 			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

51675

1 BR 09-09-16.

ST

17

44659

1

45825

1

47316

4

48556

11

D3564-5RevD

Manufactured

No

200

Each

22.0000

1.0000


Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

51655

1 BR 09-09-16.

FG

2

34806

2

Main Warehouse

FP19

12

48555

12

Main Warehouse

ST

8

45824

1

47433

1

48164

6

July 31, 2009 8:35:00 AM

Shop Packet Print

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NOTE: Date & initial all entries

Picklist Print

Page 9

July 31, 2009 8:35:00 AM

Work Order ID: 50848



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 08/20/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC		Manufactured	No			200	Each	894.0000	16.0000			
O-Ring, 205 Skidtube												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 894

27168 44

29908 ✓ 850

D2594-1RevC

Manufactured No

200

Each

700.0000

16.0000



Plug, 205 Skidtube

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 700

42221 16

42807 92

43884 87

46435 3

47251 502

51757

16 BL 09-09-16.

16 BL 09-09-16.

July 31, 2009 8:35:00 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

*10-80-50
85805
#*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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NOTE: Date & initial all entries

RELEASED
07-06-28-11

Diagram illustrating the underside of the D2576-3 step, showing the locations for grinding flush and the location ridge on the underside of the D2576.

Labels and features:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a circular component with a central hole and a rectangular slot. The drawing includes dimension lines and labels for various parts and materials:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to the central hole.
- #0.208**: Dimension line indicating the diameter of the central hole.
- AN3-SA BOLT (1)**: Points to the bolt passing through the central hole.
- AN960/D10L WASHER (1)**: Points to the washer under the bolt.
- (2 PLACES)**: Points to the two locations where the cap is installed.
- D2855 CAP**: Points to the cap being installed.
- SEAL WITH SIKAFLEX-241/-291**: Points to the sealant applied to the cap.
- 0.40**: Dimension line indicating the width of the rectangular slot.

Diagram of a wheel assembly showing components and a list of steps:

- D2579 SPACER
- D2596 WEB (REF)
- ALST-1032-130 (REF)
(TYP 50 PLACES)
- 5
- AFTER PERFORM
- 1. CHA
- 2. INS
- 3. WE
- 4. C'B

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

[illegible]

0.5 1.5 1.5

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

WELD AS PER DETAIL B

8

1.5 1.5 1.5

P P P P P P P

REFER TO DETAIL C

D3566-1 D3566-5 D3566-1 D3566-13


D3564-11 D3564-5 D3564-9 D3564-13

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

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 DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA	
DRAWING NO.	REV. D
D2580	SHEET 2 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Diagram of a circular cross-section of a pipe with four vertical stiffeners. The stiffeners are spaced 3.500 units apart. The distance from the centerline to the outer edge of the stiffeners is 1.750 units.

RELEASED
07-06-28

Diagram of a propeller hub showing grinding locations. Labels include: GRIND FLUSH (4 PLACES), GRIND FLUSH, D2576-3 STEP, GRIND FLUSH, LOCATION RIDGE ON UNDERSIDE OF D2576, and a 1/4 inch dimension.

Ø0.208

DRILL PRIOR TO D2855 CAP
INSTALLATION (2 PLACES)

AN3-SA BOLT (1)
AN960JD10L WASHER (1)
(2 PLACES)

D2855 CAP

0.40

SEAL WITH
SIKAFLEX-241/-291

SEE NOTE ii)

Diagram of a circular spacer assembly. The assembly consists of a central web (D2596) and a spacer (D2579). The web is labeled "D2596 WEB (REF)". The spacer is labeled "D2579 SPACER". The assembly is shown with a cross-section view of the web and a top view of the spacer. The spacer has a central hole and four smaller holes. The web has a central hole and four smaller holes. The assembly is shown with a cross-section view of the web and a top view of the spacer. The spacer has a central hole and four smaller holes. The web has a central hole and four smaller holes.

5

AL57-1032-130 (REF)
(TYP 50 PLACES)

D2596 WEB (REF)

D2579 SPACER

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C/BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

37.50

DISTANCE TO AFT END OF D2598 WEB

38.0

REFER TO DETAIL A

8.750

17.375

26.000

34.188

91.500

190.0
(D2500-1)

1.750

1.750

#0.508 (TYP.)
(40 PLACES)

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

REFER TO DETAIL E

Figure 1 is a plan view of the hull structure. It shows a centerline with various dimensions and callouts. The dimensions include 51.340, 39.580, 5.915, 3.630 (REF), 5.338 (REF), 5.985, 1.4, 1.0, 13.4, 1.0, 32.0 ± 1.0, and 11. Callouts include '4' (triangle), '0.640', '0.508 (8 PLACES)', and '20.0'.

D3560-045 ASSEMBLY DETAIL

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5

1.5

1.5

H

NO C'BORE NO PLUG

NO C'BORE NO PLUG

8

1.5

1.5

1.5

P

H

P

P

P

P

P

P

NO C'BORE NO PLUG

D3566-1

D3566-5

D3566-13

D3564-11


D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

DESIGN	DRAWN BY
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	07.02.27	205 SKIDTUBE ASSEMBLY		1:24

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

NO. 207

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 50849
Part number: D205-634-041
Description: 205 skt tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pct. Dwy Date of Test Coupon 09.08.27

Welder Barclay Elliott Date of Test Coupon 09.08.27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld